



Coating Holdings LTD

1137 W Fond du Lac St
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OR20C

Product Description

Unique two components, moderate viscosity casting system designed for easy processing of large parts with low exotherm.

Typical Physical Properties

Tensile Strength	ASTM D-638	3000psi
Elongation	ASTM D-638	50%
Hardness (shore D)	ASTM D-2240	65±3
Tear Strength (PLI)	ASTM D-624	400
Ratio A/B	Volume	1:1
Viscosity B side	1400-1650 cps @ 77° F	
Viscosity A side	500-700 cps @ 77° F	
Heat Distortion	ASTM 648 (264psi)	115° F
Flexural Strength	ASTM D-790	2600psi
Notched IZOD	ASTM D-256 ft-lb. /in	11.3

Liquid Component Properties

Solids weight	100%
Solids volume	100%
Specific Gravity B side	1.0-1.10 g/ml
	Depending on color
Specific Gravity A side	1.13 g/ml
Volatile Organic compounds	Contains none
Flash Point A side	370F
Flash Point B side	240F
Boiling Point A side	>530F
Boiling Point B side	> 400F

Storage Stability:

12 months in unopened containers @ 50-90° F

Usage

OR20C is primarily used to cast large urethane blocks that in turn are machined into parts

Color:

Both the Iso and Poly components are moderate viscosity clear amber liquids. When combined, rigid amber to translucent thermoset plastic is formed. Custom colors are available on request.

Application

MIXING: The mixing ratio is 1:1 by volume or 108 parts by weight of isocyanate to 100 parts polyol. Hand mix thoroughly for 4 minutes. Power mixing is mandatory in the case of large quantities or if ceramic beads are used.

Pot Life

Pot life of a 250 gram sample is 30 minutes when mixed at room temperature. Gelation is a gradual increase in viscosity beyond 30 minutes until a tack free state is reached at 2 hours.

Cure and Demold

Castings can be demolded in about 4 hours after a tack free state. OR20C will reach its maximum physical properties in five to seven days.

Primer

Self priming on most surfaces. Primer is recommended where enhanced adhesion is needed. Please contact Coating Holdings LTD for specific recommendations.

Warranty

The technical data and any other printed information furnished by Coating Holdings LTD are true and accurate to the best of our knowledge. OR20C conforms to in house quality control procedures and should be considered free of defects. The data provided is believed to be reliable and is offered solely for evaluation. The use of this product is beyond the control of the seller therefore the buyer assumes all risks of use and handling whether done in a matter that is in accordance with the provided posted directions or not. Coating Holdings LTD makes no warranty; expressed or implied, of its products and shall not be liable for indirect or consequential damage in any event.

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